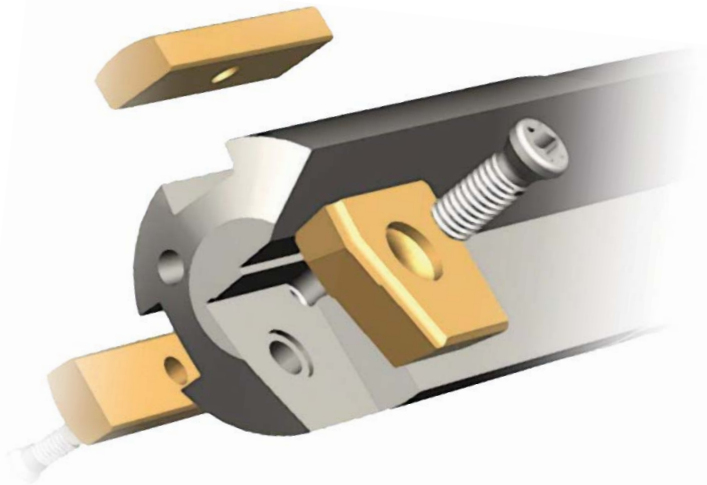


Single-fluted gun drills with interchangeable inserts

Type TBE-WP

Stock single-fluted gun drills with interchangeable inserts and supporting strips are solely available as special tools for customers specific applications. They are suitable for the machining of nearly every material and can be manufactured from diameter 12.0 mm to 52.0 mm with maximum total length up to 3.000 mm. For Drilling depth 30xD standard sizes are available ex stock.



The special advantages are:

- The interchangeable component technology for inserts and supporting strips makes any combination of carbide grade and coating possible.
- The precision interchangeable inserts and supporting strips eliminate complicated adjustments.
- The precision supporting strips are produced out of a special carbide for your individual deep drilling task. They can be reverse-fitted, providing double tool life.
- Thanks to the precision insert seatings and the interchangeable inserts there is only a small number of interchangeable components. The tool is therefore extremely rigid.
- Expensive stoppages are eliminated because the worn components can be replaced without removing the tool from the machine.
- The expensive regrinding process is eliminated thanks to the interchangeable insert technology.
- The application orientated selection of the most suitable interchangeable insert always ensures optimal chip breaking – even in problematic materials.
- Specifically optimised to your individual deep drilling task, the precision inter-changeable inserts are also made out of a special carbide grade.
- Within the diameter range it is possible to modify the nominal diameter at any time by simply interchanging the individual components.
- The drivers are produced in heat-treatable steel acc. to:
 - DIN 6535 HA
 - DIN 6535 HB
 - DIN 6535 HE
 - DIN 1835 E

Also, all other forms which are generally required for deep drilling machines are possible to be manufactured.

Size	Diameter range (mm)	Size	Diameter range (mm)	Size	Diameter range (mm)
0.00	12.00 - 12.49	3.02	27.00 - 27.49	7.04	42.00 - 42.49
0.01	12.50 - 12.99	3.03	27.50 - 27.99	7.05	42.50 - 42.99
0.02	13.00 - 13.49	3.04	28.00 - 28.49	7.06	43.00 - 43.49
0.03	13.50 - 13.99	3.05	28.50 - 28.99	7.07	43.50 - 43.99
0.04	14.00 - 14.49	3.06	29.00 - 29.49	8.00	44.00 - 44.49
0.05	14.50 - 14.99	3.07	29.50 - 29.99	8.01	44.50 - 44.99
0.06	15.00 - 15.49	4.00	30.00 - 30.49	8.02	45.00 - 45.49
0.07	15.50 - 15.99	4.01	30.50 - 30.99	8.03	45.50 - 45.99
1.00	16.00 - 16.49	4.02	31.00 - 31.49	8.04	46.00 - 46.49
1.01	16.50 - 16.99	4.03	31.50 - 31.99	8.05	46.50 - 46.99
1.02	17.00 - 17.49	4.04	32.00 - 32.49	8.06	47.00 - 47.49
1.03	17.50 - 17.99	4.05	32.50 - 32.99	8.07	47.50 - 47.99
1.04	18.00 - 18.49	4.06	33.00 - 33.49	9.00	48.00 - 48.49
1.05	18.50 - 18.99	4.07	33.50 - 33.99	9.01	48.50 - 48.99
1.06	19.00 - 19.49	5.00	34.00 - 34.49	9.02	49.00 - 49.49
1.07	19.50 - 19.99	5.01	34.50 - 34.99	9.03	49.50 - 49.99
2.00	20.00 - 20.49	5.02	35.00 - 35.49	9.04	50.00 - 50.49
2.01	20.50 - 20.99	5.03	35.50 - 35.99	9.05	50.50 - 50.99
2.02	21.00 - 21.49	5.04	36.00 - 36.49	9.06	51.00 - 51.49
2.03	21.50 - 21.99	5.05	36.50 - 36.99	9.07	51.50 - 52.00
2.04	22.00 - 22.49	5.06	37.00 - 37.49		
2.05	22.50 - 22.99	5.07	37.50 - 37.99		
2.06	23.00 - 23.49	6.00	38.00 - 38.49		
2.07	23.50 - 23.99	6.01	38.50 - 38.99		
2.08	24.00 - 24.49	6.02	39.00 - 39.49		
2.09	24.50 - 24.99	6.03	39.50 - 40.00		
2.10	25.00 - 25.49	7.00	40.01 - 40.49		
2.11	25.50 - 25.99	7.01	40.50 - 40.99		
3.00	26.00 - 26.49	7.02	41.00 - 41.49		
3.01	26.50 - 26.99	7.03	41.50 - 41.99		

Questionnaire

Single-fluted gun drills with interchangeable inserts

Ø 12.0 - 52.0 mm, flute length min. 15xD, total length max. 3000 mm

Quantity _____

Coating

- TiN
 TiCN
 TiAlN
 AlTiN nano
 AlTiN+
 AlTiN

Material

Material to be machined _____ Tensile strength/Hardness _____ N/mm²/HRC

Machine type

- Deep hole drilling machine
 Conventional machine tool

Coolant

- Deep hole drilling oil
 Soluble oil

Coolant pressure

_____ bar

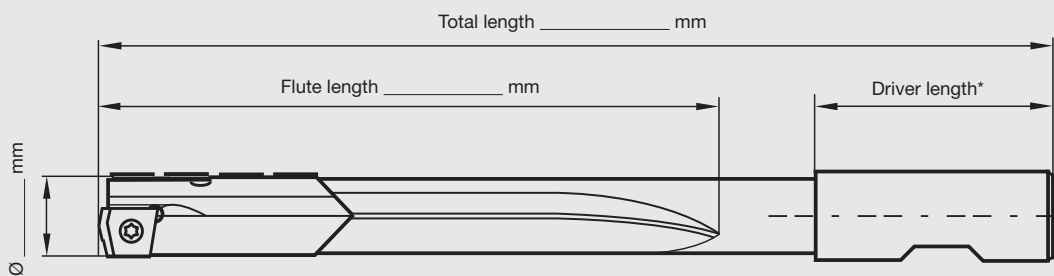
Driver

- none
 Code _____

Workpiece

Drilling depth _____ mm Hole tolerance _____

Dimensions



Contact

Company: _____

Company stamp: _____

Contact person: _____

Telephone / Fax: _____

Date: _____

Email address: _____

Signature: _____